

# Work Order ID 112836

February-10-14 7:54:02 AM

\*112836\*

Ship March 10

Page 1

Item ID: D350-636-012

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-02-10 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2750-042

G

D3492

C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

record fwd angle: 89.7

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS  
06  
9-89

MAR 24 2014

MLS 14-03-24

mm

14/02/19

B112836RH

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
<b>*110*</b>	Skidtubes								
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail J to 0.297" (total of 2 holes per side)								

mm 14/02/20

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Start Date: 2/10/14 Start Qty: 1.00 \*1\*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M127069 BE1402-20

12-Grind welds flush as per Dwg D2750

DP 14-2-20

120	QC10- Inspect visual per QSI004- ground welds	0.00							
-----	---	------	--	--	--	--	--	--	--

\*120\*

QC

Memo 0.00

Quality Control

① 14-02-20

DAS

9

9-89

130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

\*130\*

QC

Memo 0.00

Quality Control

① 14-02-20

DAS

9

9-89

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Revision ID:

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Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> Hand Finish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1	2	14-02-21	DL
150 <b>*150*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				1	0	14-02-21	

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Revision ID:

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Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>127518</u> exp. date: <u>14-8-10</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M126325</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

14-02-21 DGL

78E14-02-25

14-2-25

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**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***


QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

 14-2-25

170

QC10- Inspect visual per QSI004- ground welds 0.00

**\*170\***

QC

Memo

0.00

Quality Control

① 14-02-26

DAS

9

9-89

180

QC5- Inspect part completeness to step on W/O 0.00

**\*180\***

QC

Memo

0.00

Quality Control

\*\*\*VERIFY C'BOARD IS GOOD\*\*\*

① 14-02-26

DAS

9

9-89

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\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00  0.00				1		14-3-4	
200 *200* SprayPaint Spray Painting	Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 126543  2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 128574	0.00  0.00				1	0	0	14-3-22
210 *210* QC Quality Control	QC14- Inspect Spray Paint  Memo Inspect for foreign object per QSI 024	0.00  0.00				1RH			14/03/24

DAS  
27  
9-89

14/3/24

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Item ID: D350-636-012

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11127918EXP DATE: 11/10/09

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11127651

5-Coat all exposed fasteners with "LPS Procyon"

batch: 11127960

DAS

27

9-89

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

1 R11 / 111 1103/21

11/13/24



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**\*N900040100\***

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Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

DAS  
28  
9-89

14-03-24

DAS  
31  
9-89

DAS  
06  
9-89

MAR 24 2014

MAR 25 2014

*[Signature]*

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 14-03-25  
MLJ 14-03-25

# Picklist Print

February-10-14 7:54:08 AM

Page 1

Work Order ID: 112836

\*112836\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K  
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-  
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

24.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

mm 14/02/14

Location

Loc Qty

Loc Code

LG

22

110478

1

111600

21

LG002

2

109789

2

D2744

Manufactured

No

110

Each

32.0000

1

1

\*D2744\*

Cap

\*\*

BF14-02-20

Location

Loc Qty

Loc Code

LG001

32

100398

27

97543

5

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Work Order ID: 112836

**\*112836\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

12.0000

1

1

**\*D2739\***

350 I Beam

\*\*

Location

Loc Qty

Loc Code

LG

112596  
110835

9

5

111609

4

LG002

3

109973

3

D2743

Manufactured No

160

Each

304.0000

8

8

**\*D2743\***

Crossbolt Spacer

\*\*

Location

Loc Qty

Loc Code

LG

111570

169

169

LG001

107907

135

118

109799

17

D3490-3

Manufactured No

160

Each

60.0000

4

4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

Location

Loc Qty

Loc Code

LG001

107913

60

40

109933

20

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\*112836\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 119.0000 4 4

\*D3490-1\*

Cross Bolt Spacer

\*\*

## Location

## Loc Qty

## Loc Code

LG001 119  
107419 4  
109932 115

BEB-02-24  
B112737 x4

D3631-1 Manufactured No 230 Each 364.0000 8 8

\*D3631-1\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

FP001 364  
110258 64  
111019 100  
111546 200

11/03/24

D3791-1 Manufactured No 230 Each 21.0000 1 1

\*D3791-1\*

Wearpad

\*\*

## Location

## Loc Qty

## Loc Code

FP002 21  
109511 10  
110212 11

13112413

11/03/24

D3793-3 Manufactured No 230 Each 18.0000 1 1

\*D3793-3\*

Wearplate Aft

\*\*

## Location

## Loc Qty

## Loc Code

FP001 5  
104212 5  
FP002 13  
110066 13

13110887

11/03/24

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Shop Packet Print

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

486.0000

4

4

\*MS21043-6\*

NUT

\*\*

11/03/21

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST315

216

m127255

216

ST509

250

m127813

250

D3794-1

Manufactured

No

230

Each

19.0000

1

1

\*D3794-1\*

Gasket Fwd

\*\*

11/03/21

## Location

## Loc Qty

## Loc Code

FP001

19

108497

4

109207

3

110316

12

NAS1611-010

Purchased

No

230

Each

135.0000

8

8

\*NAS1611-010\*

O-RING

\*\*

11/03/21

## Location

## Loc Qty

## Loc Code

FP001

135

m126988

3

m127813

132

M128375

x6

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Shop Packet Print

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

32.0000

1

1

**\*D2741\***

Blade

\*\*

DAS  
28  
9-89

14-03-24

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

21

107206

21

110710

DAS  
37  
9-89

NAS1515H3L

Purchased

No

230

Each

440.0000

4

4

**\*NAS1515H3I \***

Washer

\*\*

14/03/24

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

400

m127831

400

14/03/24

NAS1611-013

Purchased

No

230

Each

106.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

14/03/24

Location

Loc Qty

Loc Code

FP001

106

m127813

106

11128375

14/03/24

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\*112836\*

Parent Item: D350-636-012

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 461.0000 4 4

\*AN3C6A\*

Bolt

\*\*

11/03/21

## Location

## Loc Qty

## Loc Code

FG

10

11282241

x1

122416

10

ST513

451

m125709

451

NAS1149C0832R Purchased No 230 Each 353.0000 1 1

\*NAS1149C0832R\*

Washer

\*\*

11/03/21

## Location

## Loc Qty

## Loc Code

ST292

353

122441

86

x1

m114915

117

m125807

150

D3536-25 Manufactured No 230 Each 25.0000 1 1

\*D3536-25\*

Gasket Center

\*\*

11/03/21

## Location

## Loc Qty

## Loc Code

FG

6

1311417

x1

87053

2

95328

4

FP001

19

109206

7

110652

12

February-10-14 7:54:08 AM

Shop Packet Print

Page 6



# Picklist Print

February-10-14 7:54:08 AM

Page 7

Work Order ID: 112836

**\*112836\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 11.0000 1 1

**\*D3794-3\***

Gasket Aft

\*\*

lll 11/03/21

## Location

## Loc Qty

## Loc Code

FP001

11

B113060

x1

108413

11

AN3C5A Purchased No 230 Each 1,881.000 34 34

**\*AN3C5A\***

Bolt

\*\*

lll 11/03/21

## Location

## Loc Qty

## Loc Code

FG

5

122800

5

ST350

1876

M128057

1876

x34

D3537-1 Manufactured No 230 Each 145.0000 3 3

**\*D3537-1\***

Wearpad

\*\*

lll 11/03/21

## Location

## Loc Qty

## Loc Code

FG

18

79833

8

88562

10

FP001

127

110821

72

111594

55

B114585

x3

February-10-14 7:54:08 AM

Shop Packet Print

Page 7

# Picklist Print

February-10-14 7:54:08 AM

Page 8

Work Order ID: 112836

\*112836\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

30.0000

1

1

\*D3535-25\*

Wearplate Center

\*\*

ll 11/03/21

## Location

## Loc Qty

## Loc Code

FG

2

95077

2

13112385

x1

FP002

28

106128

5

110193

11

110744

12

D3492-3

Manufactured No

230

Each

340.0000

8

8

\*D3492-3\*

Plug

\*\*

ll 11/03/21

## Location

## Loc Qty

## Loc Code

FP001

340

104853

24

107331

93

109800

100

111553

123

x8

NAS1149C0332R

Purchased No

230

Each

9,640.000

38

38

\*NAS1149C0332R\*

WASHER

\*\*

ll 11/03/21

## Location

## Loc Qty

## Loc Code

GA

1157

125654

1157

st510

8483

m126319

865

m127306

2500

m127410

3000

m127831

2118

x38

February-10-14 7:54:08 AM

Shop Packet Print

Page 8

# Picklist Print

February-10-14 7:54:08 AM

Page 9

Work Order ID: 112836

**\*112836\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Agrazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

16.0000

1

1

**\*D3488-042\***

Blade Fitting RH

\*\*

11/03/24

Location

Loc Qty

Loc Code

FP001

16

106658

6

109134

7

98887

3

2,056.000

38

38

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

**\*ALS4-1032-225\***

Rivnut

\*\*

11/03/24

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

1970

M127028

10

M128179

1960

st555

56

M127092

56

308.0000

8

8

D3492-1

Manufactured

No

230

Each

**\*D3492-1\***

Plug

\*\*

11/03/24

Location

Loc Qty

Loc Code

FP001

308

104844

135

111578

173

13112738

18

February-10-14 7:54:08 AM

Shop Packet Print

Page 9



# Picklist Print

February-10-14 7:54:08 AM

Page 10

Work Order ID: 112836

**\*112836\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No 230 Each 13.0000 1 1

**\*D3793-1\***

Wearplate Fwd

\*\*

*ll 11/03/21*

Location

Loc Qty

Loc Code

FP002

13

B110924

110121

13

*xl*

AN8C35A Purchased No 230 Each 118.0000 1 1

**\*AN8C35A\***

Bolt

\*\*

*ll 11/03/21*

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

114

m126293

40

m127061

24

m127823

50

*xl*

MS21083C8 Purchased No 230 Each 142.0000 1 1

**\*MS21083C8\***

Nut

\*\*

*ll 11/03/21*

Location

Loc Qty

Loc Code

ST319

142

m127255

21

m127813

46

m128119

75

*xl*



# Picklist Print

February-10-14 7:54:08 AM

Page 11

Work Order ID: 112836

\*112836\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each

404.0000 8 8

\*D2745\*

Bushing

\*\*

ll 11/03/24

## Location

## Loc Qty

## Loc Code

ST017 404  
107336 124  
110526 100  
111554 180

AN6C44A Purchased No 230 Each

26.0000 4 4

\*AN6C44A\*

Bolt

\*\*

ll 11/03/24

## Location

## Loc Qty

## Loc Code

FG 2  
103964 2  
ST340 24  
m127300 24

D3532-1 Manufactured No 250 Each

76.0000 2 2

\*D3532-1\*

Spacer

DAS  
06  
9-89

\*\*

DAS  
28  
9-89

14-03-24

## Location

## Loc Qty

## Loc Code

ST054 76  
100519 16  
109803 60

MS21083C8 Purchased No 250 Each

142.0000 2 2

\*MS21083C8\*

Nut

\*\*

DAS  
28  
9-89

DAS  
31  
9-89

## Location

## Loc Qty

## Loc Code

ST319 142  
m127255 21  
m127813 46  
m128119 75

DAS  
06  
9-89

2X

February-10-14 7:54:08 AM

Shop Packet Print

Page 11

# Picklist Print

February-10-14 7:54:08 AM

Work Order ID: 112836

**\*112836\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

979.0000

2

2

**\*NAS1149D0863.I\***

Washer

\*\*

DAS

28

9-89

14-03-24

DAS

31

9-89

DAS

06

9-89

## Location

## Loc Qty

FP001

4

118078

4

ST293

175

125484

175

ST510a

800

125268

600

125635

200

## Loc Code

233.0000

2

2

\*\*

DAS

28

9-89

DAS

31

9-89

D3493-1

Manufactured

No

250

Each

**\*D3493-1\***

Washer

\*\*

DAS

28

9-89

DAS

31

9-89

DAS

16

9-89

## Location

## Loc Qty

FG

10

97201

10

ST051

223

105613

4

107916

60

109105

159

## Loc Code

\*\*\*ONLY INSTALL IF INSTALLING ON APICAL  
FLOAT SYSTEM\*\*\*



# Picklist Print

February-10-14 7:54:08 AM

Page 13

Work Order ID: 112836

**\*112836\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 2/10/14

Required Date: 2/24/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

79.0000

2

2

**\*AN8C21A\***

Bolt

**\*\***

**DAS  
28  
9-89**

14-03-24

Location

Loc Qty

Loc Code

**DAS  
06  
9-89**

ST

2

123966

2

st339

27

m127061

27

ST508

50

m127823

50

128319

**DAS  
31  
9-89**

February-10-14 7:54:08 AM

Shop Packet Print

Page 13

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

#### GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

112836 MJS  
14-02-10

RELEASED  
2013-08-13  
W

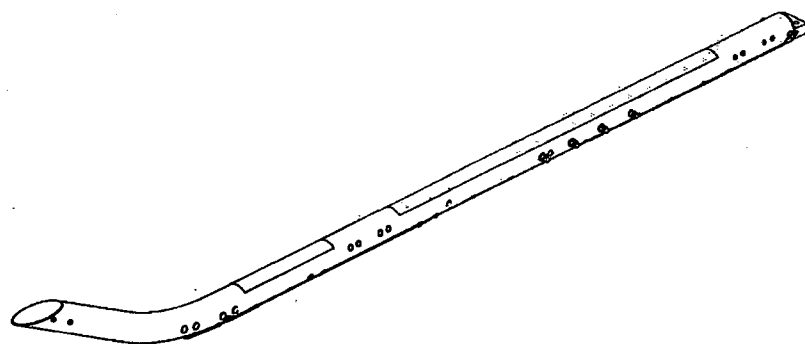
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$ , WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (36) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.  
KENT, WA

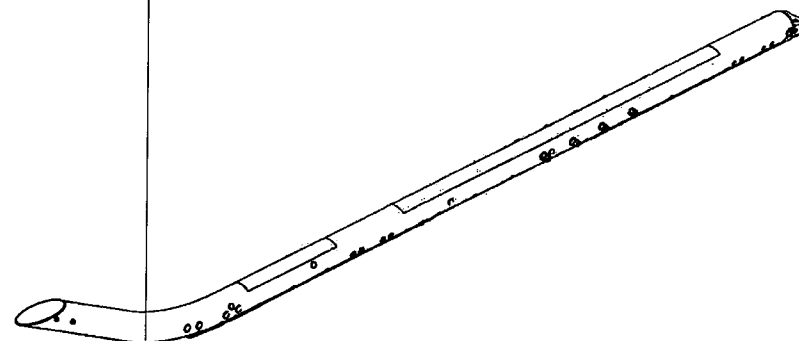
DRAWING NO.  
D2750  
TITLE  
350 SKIDTUBE ASSEMBLY

REV. G  
SHEET 1 OF 11  
SCALE  
NTS

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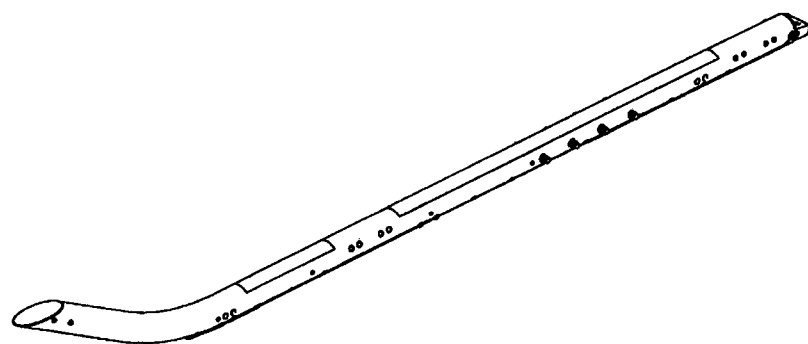
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



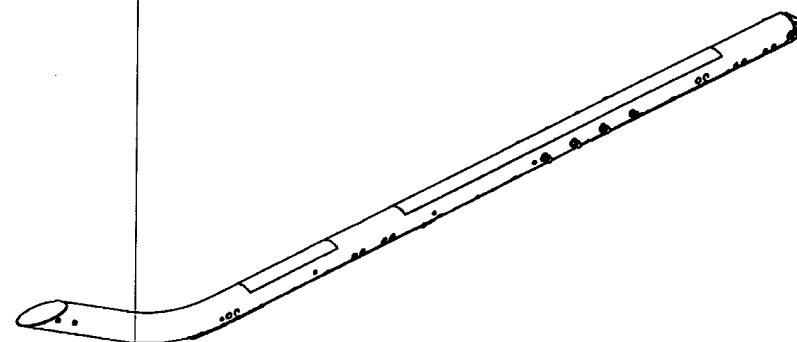
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
MP

DESIGN	MM	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN			
CHECKED		DRAWING NO. <b>D2750</b>	REV. G SHEET 2 OF 11
MFG. APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
APPROVED		<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY DISSEMINATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	
DE APPR.			
DATE	13.07.11		



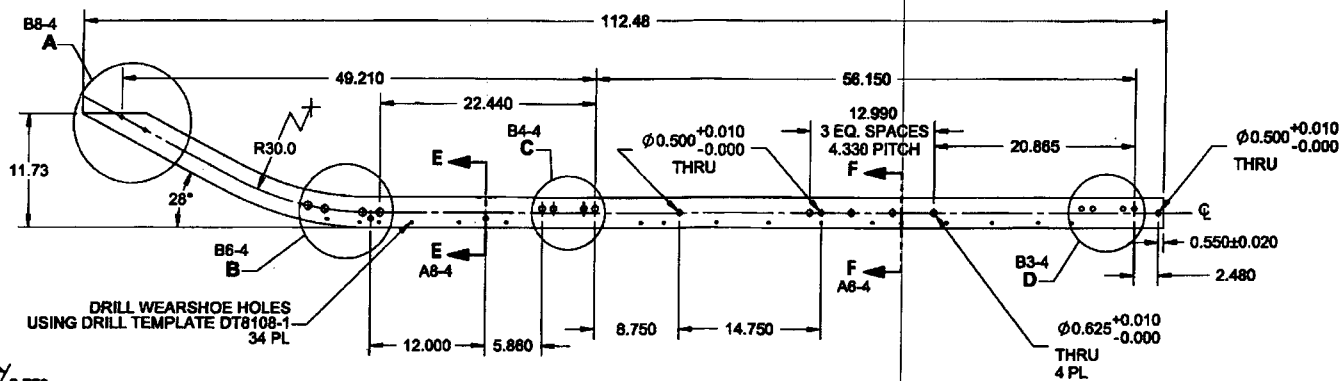
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



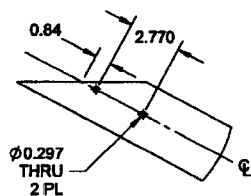
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
*MP*

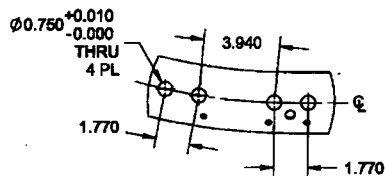
DESIGN	MM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	<b>D2750</b>	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>13.07.11</b>	<small>COPYRIGHT © 1986 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



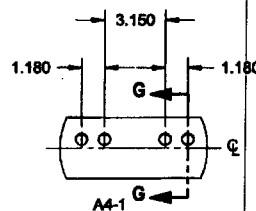
**D2750-1 LH SKIDTUBE**



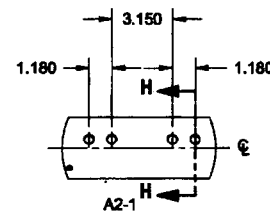
**DETAIL A**  
SCALE 2X



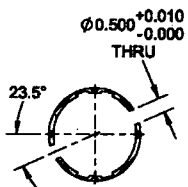
**DETAIL B**  
SCALE 2X



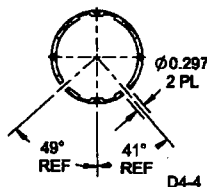
**DETAIL C**  
SCALE 2X



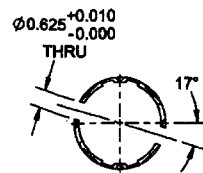
**DETAIL D**  
SCALE 2X



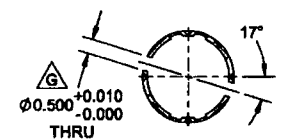
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



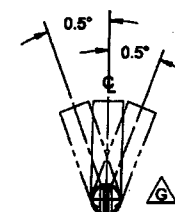
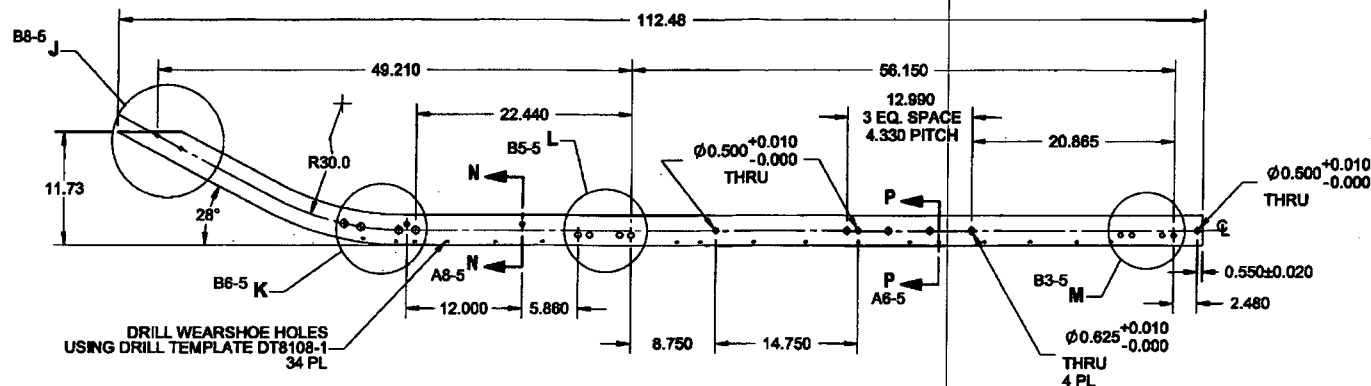
**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

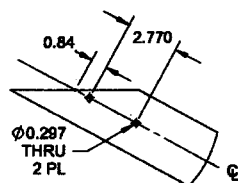
**RELEASED**  
2013-08-13

DESIGN	MM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. G
MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.		NTS	
DATE	13.07.11	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

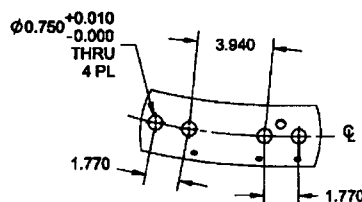


MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

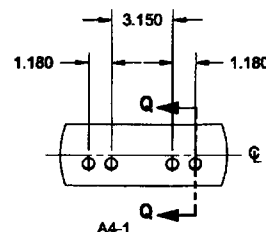
### D2750-2 RH SKIDTUBE



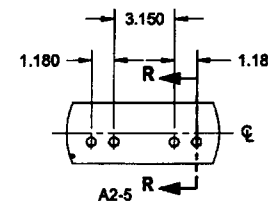
DETAIL J  
SCALE 2X



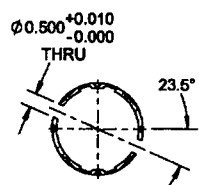
DETAIL K  
SCALE 2X



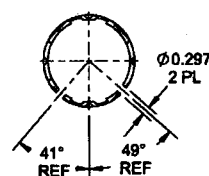
DETAIL L  
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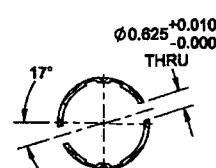
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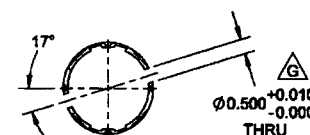
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SCALE 3X, 2 PL



SECTION P-P  
SCALE 3X, 17 PL



SECTION Q-Q  
SCALE 3X, 4 PL

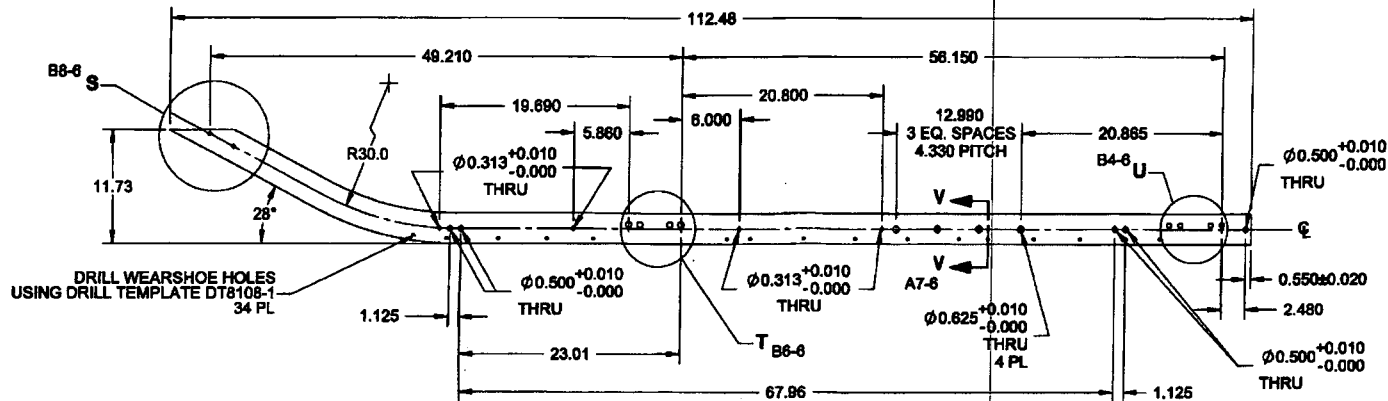


SECTION R-R  
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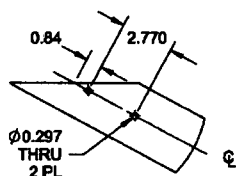
RELEASED  
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DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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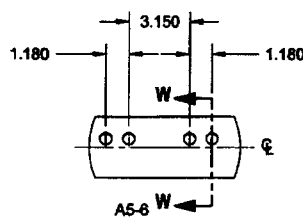
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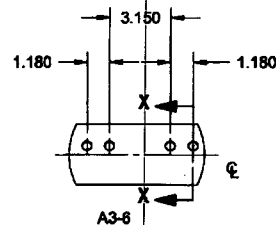
**D2750-3 LH SKIDTUBE**



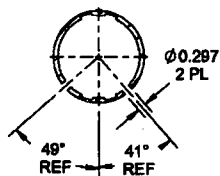
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D8-6  
SCALE 2X



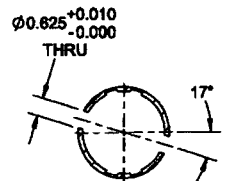
**DETAIL T**  
C5-6  
SCALE 2X



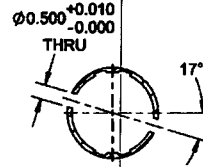
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL





**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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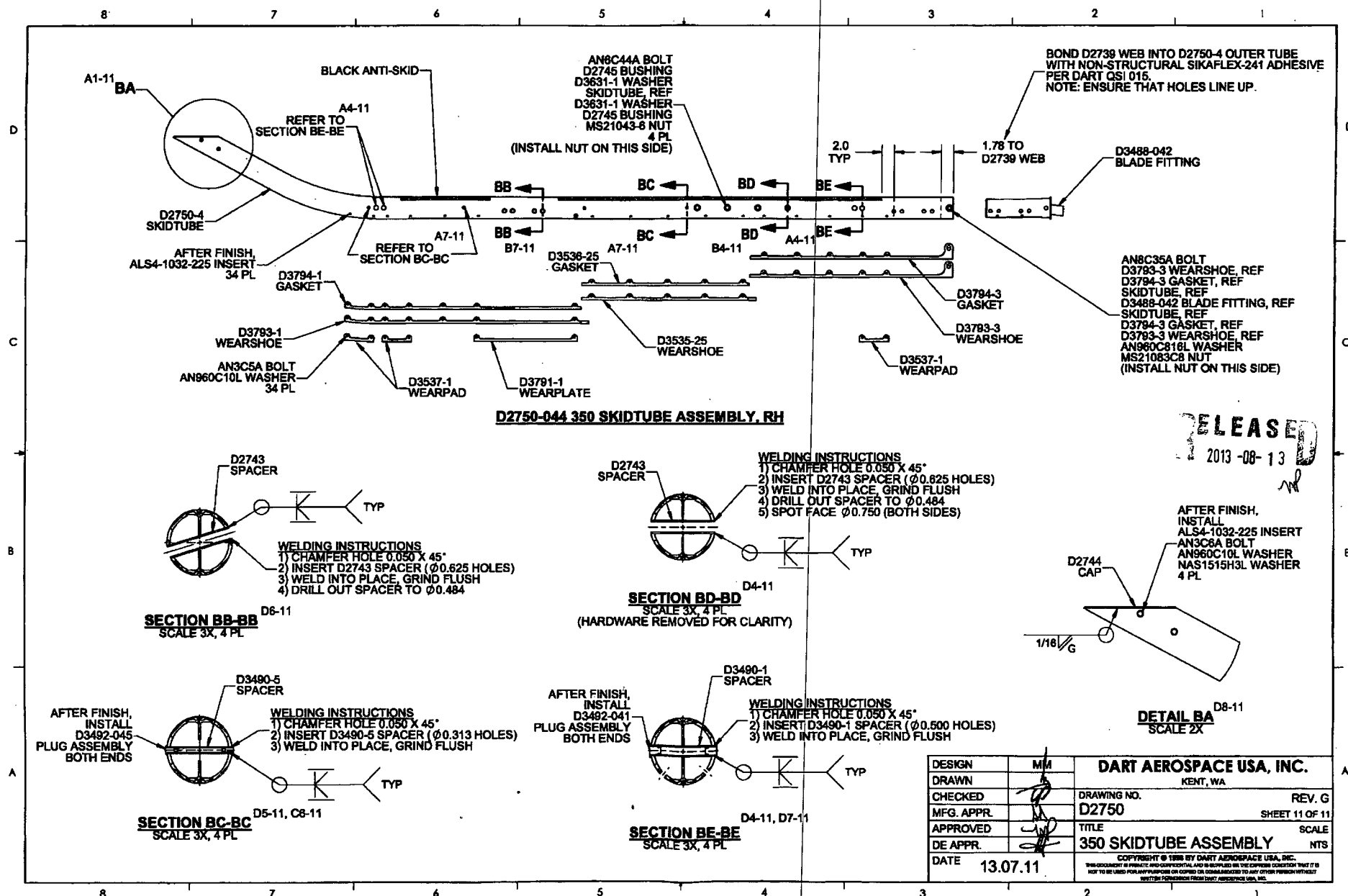












No. 336

**AWS D17.1/D17.1M:2010  
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott  
Job #: 112540  
Part #: D350-606-D12  
Description: 350 skid tube  
Welding Process: TIG ☒ MIG ☐  
Base Material: Aluminium  
Current: AC ☒ DC ☐

**TEST REQUIREMENTS AND RESULTS**

Visual:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Penetration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Fusion:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/> fail <input type="checkbox"/>

Qualifier: <sup>DAS</sup>  
E  
19-89

Date of Test Coupon: 14-02-15

Welder: Barclay Elliott

Date of Test Coupon: 14-02-19

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.

